

Work Order ID 72176

Tuesday, July 19, 2011 1:53:27 PM



Page 1

Item ID: D3407-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Stem

Start Date: 7/19/2011 Start Qty: 16.00



Cust Item ID:

Required Date: 7/25/2011 Req'd Qty: 16.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 11-07-19

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3407	Rev E

100

0.00



DOOSAN LATHE

Doosan

Memo

0.00

Doosan Lathe

1-Turn as per Folio FA596 Rev: E & Dwg D3407 Rev: E □2-Deburr

11/8/8

16

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

11/8/8

16

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

Per 11.8.10

16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>WA</u>	0.00							
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/8/10 SP (16)

CK 11/08/10

11-05-10
(16)

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Picklist Print

Tuesday, July 19, 2011 1:53:33 PM

Page 1

Work Order ID: 72176

Parent Item: D3407-1

Parent Item Name: Stem




Start Date: 7/19/2011

Required Date: 7/25/2011

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP Rev:A 05.10.18 New issue KJ/EC
IPP Rev:B Now on Doosan 08-05-14 JLM Verified By:DD
IPP Rev:C 08-08-12 revE as per dwg (ecn 08-507) DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M174R0.750  17-4 round bar .750		Purchased	No			100	f	6.4650	0.366	6.164211			

Location

MAT030

Loc Qty

6.465

Loc Code

118483

8 RA



SN 11818

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

DART AEROSPACE LTD		Work Order:	72176
Description: Tow Ring		Part Number:	D3407-1
Inspection Dwg: D3407 Rev: E		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.063	+/-0.010	0.065	/		MS	
1/4-28 UNF	Max: 0.2668 Min: 0.2635	0.265	/		MS	
Major Ø	Max: 0.249 Min: 0.2425	0.245	/			
Ø0.625	+/-0.010	0.621	/			
Ø0.363	+/-0.010	0.362	/			
Ø0.750	+/-0.010	0.748	/			
R0.100	+/-0.010	0.100	/			
0.470	+/-0.010	0.470	/			
0.500	+/-0.010	0.500	/			
3.250	+/-0.010	3.245	/			
4.250	+0.000/-0.010	4.245	/			
5.270	+/-0.010	5.270	/			
0.150	+/-0.010	0.154	/			
0.550	+/-0.010	0.554	/			
0.625	+/-0.010	0.622	/			
0.250	+0.010/-0.000	0.252	/			

Measured by:		Audited by:		Prototype Approval:	N/A
Date:	11/18/18	Date:	11.8.10	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.19	New Issue	KJ/JLM	
B	07.07.18	Tolerances for diameters updated per Machinists	KJ/JLM	
C	08.05.14	Dimensions updated per Dwg Rev D	KJ/JLM	
D	08.10.07	Dimensions updated per Dwg Rev E	KJ/DD	 

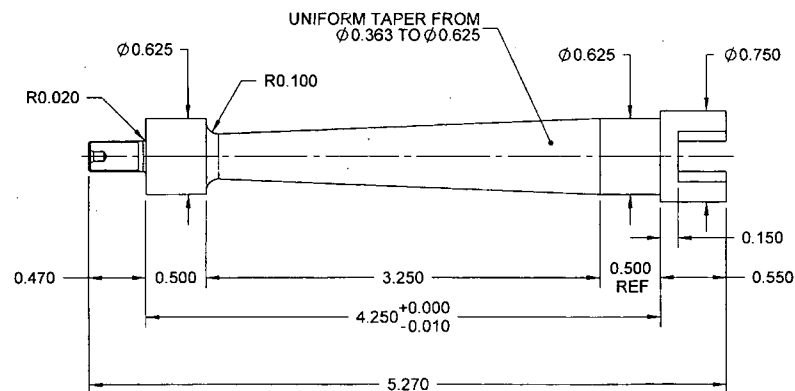
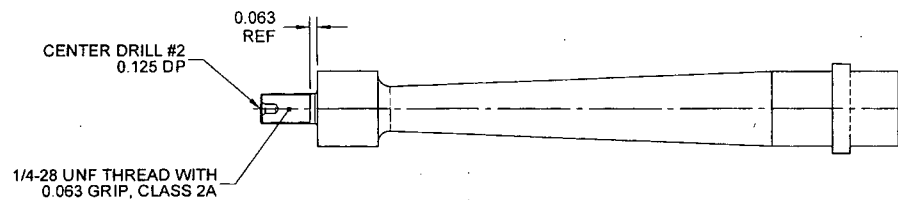
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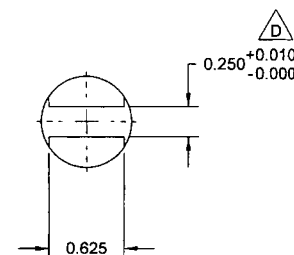
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


D3407-1 STEM



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 72174

RELEASED
08-07-23

- NOTES:
- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.33 lbs

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3407	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		TOW RING	NTS
DATE	08.07.23	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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